

Work Order ID 137170***137170***

Page 1

Item ID: D139-799-015

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Engine Wash

Stop ***NS2***

Start Date: 10/05/15 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/15/15 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLS Date: SEP 23 15 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D139-799	J

MLSMLS 15-10-08

100

Document Control

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D139-799-015
CHG005IXDAS
28
9-89NOV 27 2015

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

MLS15-10-05

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

IXDAS
28
9-89NOV 27 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 137170

Thursday, September 24, 2015 2:11:28 PM

137170

Page 2

Item ID: D139-799-015

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Engine Wash

Stop ***NS2***Start Date: 10/05/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/15/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00						DAS 28 9-89	NOV 27 2015
Packaging	Identify and pack for shipping as per PPP D139-799-015								
	Location: <u>FG 09</u>								
	PPP rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

ML5 15-11-27

ML5 15-11-27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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OTHER :																																																																																																																															

Picklist Print

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Page 1
14

Work Order ID: 137170

137170

Parent Item: D139-799-015

D139-799-015

Parent Item Name: Engine Wash

Start Date: 10/05/15

Required Date: 10/15/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B 11.07.04 new issue DD verf:JLM IPP REV:B
AS PER ECN 11-598 11-06-05 JLM VERF BY:DD IPP Rev:C 11.09.27
PER CHG003 DD verf:EC IPP Rev:D 13.09.24 PER
CHG005/ECN13-579 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4121-1		Manufactured	No			110	Each	6.0000	2	2			
D4121-1									**			MLJ	
Hose Assy													

DAS
28
9-89

Location	Loc Qty	Loc Code
FG	3	
114101	1	
132053	2	
ST214	3	
135082	1	
135590	2	

D4121-3		Manufactured	No			110	Each	5.0000	1	1			
D4121-3									**			MLJ	
Hose Assy													

DAS
28
9-89

Location	Loc Qty	Loc Code
FG	1	
91535	1	
ST213	3	
135566	3	
ST214	1	
129024	1	

OCT 05 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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OTHER :																																																															

Picklist Print

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Page 2

Work Order ID: 137170

137170

Parent Item: D139-799-015

D139-799-015

Parent Item Name: Engine Wash

Start Date: 10/05/15

Required Date: 10/15/15

Start Qty: 1.00

Required Qty: 1.00

D4121-5 Manufactured No

110 Each 5.0000 1 1

D4121-5

Hose Assy

**

MLJ

DAS
28
9-89

Location

Loc Qty

Loc Code

ST214

5

129025

1

135513

4

D4131-041

Manufactured No

110 Each 0.0000 1 1

D4131-041

Manifold Assembly

DAS
28
9-89

**

137617

D4131-043

Manufactured No

110 Each 5.0000 1 1

D4131-043

Doubler Assembly

DAS
28
9-89

**

MLJ

Location

Loc Qty

Loc Code

ST093

5

135217

5

D4146-1

Manufactured No

110 Each 4.0000 2 2

D4146-1

Fitting

DAS
28
9-89

**

137090

Location

Loc Qty

Loc Code

ST093

4

132335

4

D4182-1

Manufactured No

110 Each 14.0000 2 2

D4182-1

Fitting, Quick Disconnect

DAS
28
9-89

**

MLJ

Location

Loc Qty

Loc Code

ST097

14

135218

4

135715

10

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Shop Packet Print

OCT 05 2015

Page 2

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Picklist Print

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Page 3

Work Order ID: 137170

137170

Parent Item: D139-799-015

D139-799-015

Parent Item Name: Engine Wash

Start Date: 10/05/15

Required Date: 10/15/15

Start Qty: 1.00

Required Qty: 1.00

D4384-1

Manufactured No

110

Each

9.0000

1

1

D4384-1

Placard

MLJ

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

5

80679

5

ST103

4

133324

4

AN526-1032R16

Purchased

No

110

Each

62.0000

4

4

AN526-1032R16

Screw

MLJ

DAS
28
9-89

Location

Loc Qty

Loc Code

ST325A

50

m133234

50

ST326

12

m130928

12

AN832-6J

Purchased

No

110

Each

21.0000

2

2

AN832-6.J

Union

MLJ

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK06

8

m133234

8

ST332

13

m133031

13

2

OCT 05 2015

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Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 137170

137170

Parent Item: D139-799-015

D139-799-015

Parent Item Name: Engine Wash

Start Date: 10/05/15

Required Date: 10/15/15

Start Qty: 1.00

Required Qty: 1.00

AN924-6J

Purchased

No

110

Each

28.0000

4

4

AN924-6.J

NUT

**

MLJ

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK06

12

m133234

12

FG

4

123245

2

m132256

2

ST322

12

m133031

12

Each

187.0000

20

MS21919-WDG9

Purchased

No

MS21919-WDG9

Clamp

**

MLJ

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK06

100

m133234

100

ST297

87

m133031

87

110

Each

39.0000

4

4

NAS1149C0932R

Purchased

No

NAS1149C0932R

WASHER

**

MLJ

DAS
28
9-89

Location

Loc Qty

Loc Code

ST271

39

m131026

39

OCT 05 2015

Thursday, September 24, 2015 2:11:28 PM

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Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
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Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				

Work Order ID 137170

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137170

Page 1

Item ID: D139-799-015

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Engine Wash

Stop

NS2

Start Date: 10/05/15 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/15/15 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJDate: 9/24/15

Tooling:

Date:

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D139-799	J								
100	Document Con	0.00							
100									
DC									
Doc.Control -USB or Paperwork									
	M: <u>D4146-1 X2</u>	0.00							
	Ph: <u>D4131-041 X1</u>	799-015							
	CI: _____								
110	Pick Kit	0.00							
110									
Packaging									
Packaging	Memo	0.00							
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC									
Quality Control	Memo	0.00							

MLJ OCT 03 2015

5.0 PARTS LIST

Qty -011	Qty -012	Qty -015	Qty -017	Qty -019	Qty -112	Qty -211	Qty -212	Part Number	Description
X								D139-799-011	MAINTENANCE STEP KIT, LH
	X							D139-799-012	MAINTENANCE STEP KIT, RH
		X						D139-799-015	ENGINE WASH KIT
			X					D139-799-017	CARGO FLOOR PROTECTOR KIT
				X				D139-799-019	CABIN FLOOR PROTECTOR KIT
					X			D139-799-112	MAINTENANCE STEP WITH GRAB BAR KIT, RH
						X		D139-799-211	QUICK RELEASE MAINTENANCE STEP KIT, LH
							X	D139-799-212	QUICK RELEASE MAINTENANCE STEP KIT, RH
			2					D3580-1	JOGGLE BRACKET
			2	8				D3628-1	CUPPED WASHER
	1							D4092-041	MAINTENANCE STEP ASSEMBLY
		2						D4092-042	MAINTENANCE STEP ASSEMBLY
		1						D4121-1	HOSE ASSEMBLY
		1						D4121-3	HOSE ASSEMBLY
		1						D4121-5	HOSE ASSEMBLY
				1				D4130-1	FWD CABIN FLOOR PROTECTOR
				1				D4130-3	AFT CABIN FLOOR PROTECTOR
			1					D4130-5	FWD CARGO FLOOR PROTECTOR
			1					D4130-7	CENTER CARGO FLOOR PROTECTOR
			1					D4130-9	AFT CARGO FLOOR PROTECTOR
		1						D4131-041	MANIFOLD ASSEMBLY
		1						D4131-043	DOUBLER ASSEMBLY
		2						D4146-1	FITTING
			1					D4153-1	JOGGLE BRACKET
			1					D4153-3	JOGGLE BRACKET
				4				D4153-5	CLAMP PLATE
			2					D4166-1	PLACARD, MAX LOAD
		2						D4182-1	FITTING, QUICK DISCONNECT
		1						D4384-1	PLACARD
					1			D4526-042	MAINTENANCE STEP ASSEMBLY, RH
						1		D5238-041	MAINTENANCE STEP ASSEMBLY
							1	D5238-042	MAINTENANCE STEP ASSEMBLY
						1	1	D5238-043	LOWER BRACKET, AFT
						1	1	D5238-045	LOWER BRACKET, FWD
						1	1	D5245-1	MOUNTING BOLT
2	2				2	2	2	AN6H12A	BOLT
2	2				2	1	1	AN6H13A	BOLT
		4						AN526-1032R16	SCREW
		2						AN832-6J	UNION
		4						AN924-6J	NUT
		20						MS21919WDG09	CLAMP
6	6				6	5	5	NAS1149D0663J	WASHER (or AN960JD616)
		4						NAS1149C0932R	WASHER (or AN960C916L)

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